

Work Order ID 58010

April 21, 2010 12:56:54 PM



Page 1

Item ID: D3696-041

Accept



Setup Start



Revision ID:

Item Name: Arm Assembly

Stop



Start Date: 21/04/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

RF

Date: 10-4-21

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3696	Rev C

100		0.00							
	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blank 17.600" long								

10/04/28

4 0

110		0.00							
	CONVENTIONAL MILLING MACHINE								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	MILL AS PER DWG AND FOLIO FA918								
	DWG REV: <i>C</i>								
	FOLIO REV: <i>C</i>								
	DEBURR								

10/04/29

4 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

mm= 10/04/29

4 0

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

A.A 10/04/29

4 0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

(4) BR 10-5-4 0.00

Hand Finishing

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location: 285

0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-5-12 SL (40)

10/05/13 AJ
10-5-12
(4)

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 58010

Parent Item: D3696-041

Parent Item Name: Arm Assembly


Comments: IPP Rev:A New Issue 08-05-01 JLM Verified By:EC
 IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP
 REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Date: 21/04/2010

Required Date: 28/04/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M7075T6B1.000X1.000		Purchased	No			100	f	12.0000	6.1231			
												
7075 T6 BAR 1.00 x1.00												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

12

114415

12

D3799-1

Manufactured

No

170

Each

52.0000

4.0000



Oilite Bronze Bushing



6.1231 DA 10/04/28

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST088

52

44915 ✓

52

D3801-3

Manufactured

No

170

Each

16.0000

4.0000



Hand Retractable Spring Plunger



4X m-l
10/05/10

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST088

16

55571 ✓

16

4X m-l
10/05/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

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Parent Item: D3696-041



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IPP Rev:B 08-07-22 redesign part (prelim) DD verified by:EC IPP
REV:C NOW ON CNC MILL 10-03-17 JLM VERIFIED BY:DD

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
MS21209C8-20		Purchased	No			170	Each	153.0000	4.0000			



Heli Coil Insert



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST305

153

108066 ✓

153

4x m-l
10/05/10

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

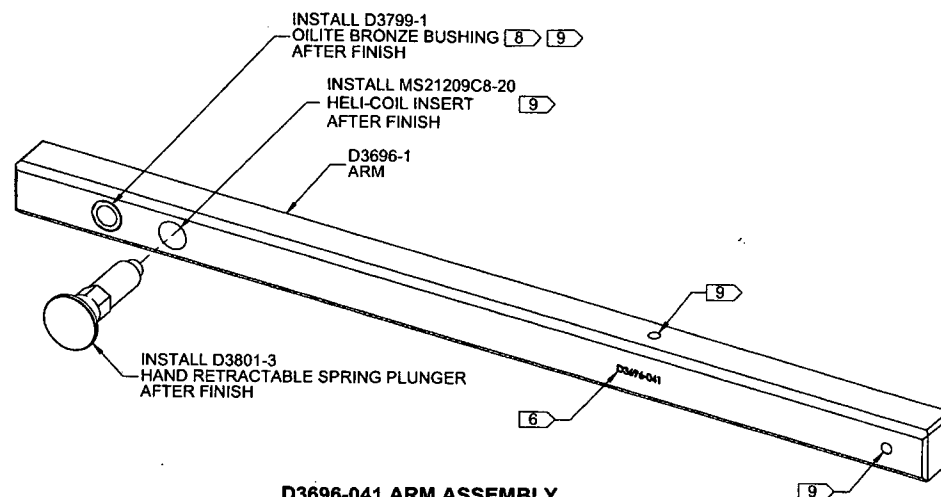
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3696-041	ARM ASSEMBLY
5	1	D3696-1	ARM
6	1	D3799-1	OILITE BRONZE BUSHING
7	1	D3801-3	HAND RETRACTABLE SPRING PLUNGER
11	1	MS21209C8-20	HELI-COIL, SCREW LOCKING (RED)



D3696-041 ARM ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58010
B/10-4-21

RELEASED
9/16/21

D3696-041 NOTES:

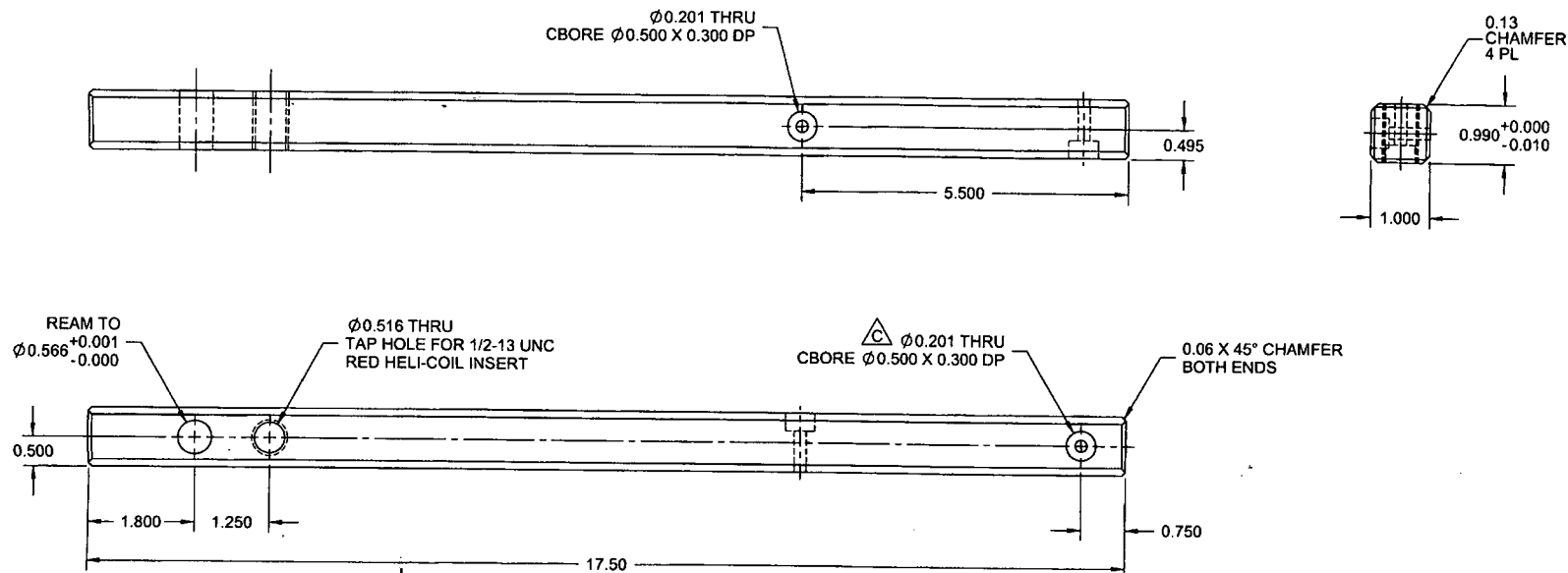
- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3696-041" USING FINE POINT PERMANENT INK MARKER LOCATED APPROXIMATELY AS SHOWN
- 7) WEIGHT: 1.69 lbs
- 8) FACE D3799-1 OILITE BRONZE BUSHING FLUSH TO D3696-1 ARM AS REQUIRED ON BOTH SIDES PRIOR TO POWDER COATING
- 9) MASK HOLES AS SHOWN PRIOR TO POWDER COATING

C	REVISED ITEM 5 AS FOLLOWS: Ø0.201 THRU CBORE Ø0.500 X 0.300 DP WAS 2 PL (ZN C4-2) REASON: REDESIGNED ARMREST CUSHION BASED ON FEEDBACK FROM END USERS AT HAI 2009	MB	09.06.17
B	P/N D3799-1 WAS BNT-137 (ZN D6-1); P/N D3801-3 WAS PRT-12 (ZN C7-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3799 AND D3801 SPEC CONTROL DRAWINGS; ADDED Ø0.201 HOLE AND CBORE (ZN C6-2 AND D5-2); 17.50 WAS 19.50 (ZN B5-2); 1.000 WAS 0.890 +0.000/-0.010 (ZN C2-2); POCKETS REMOVED REASON: ELIMINATED FWD-AFT ARMREST ADJUSTMENT	MB	08.07.17
A	NEW ISSUE	MB	08.04.18
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3696** REV. C
SHEET 1 OF 2
TITLE **ARM ASSEMBLY** SCALE NTS

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W/O 58010

RELEASED

D3696-1 NOTES:

- 1) MATERIAL: 7075-T6 (OR T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/9 (OR AMS 4122/4123/4186/4187) OR
PER AMS-QQ-A-200/11
REF. DART SPEC. M7075T6B
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.63 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3696	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		ARM ASSEMBLY	NTS
DATE	09.06.17	COPYRIGHT © 2006 BY DART AEROSPACE LTD	
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